

*DUPLICATE*

Work Order ID 96353

\*96353\*

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February-08-13 8:43:52 AM

Item ID: D4435-5 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Mount Bracket  
 Start Date: 1/24/13 Start Qty: 15.00 \*15\* Cust Item ID:  
 Required Date: 2/04/13 Req'd Qty: 15.00 \*15\* Customer:  
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4435	B								
100		0.00							
*100*	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<i>6061.040</i>	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

*21 0 Jm13-2-8*

*21 0 Jm13-2-8*

*DAS  
15  
2.00  
13-2-8*

*21*

**\*96353\***

February-08-13 8:43:52 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 1/24/13      **Start Qty:** 15.00

**\*15\***

**Cust Item ID:**

**Required Date:** 2/04/13      **Req'd Qty:** 15.00

**\*15\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Bend as per dwg

0.00

**\*130\***

Brake NC

## Memo

0.00

Brake NC

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

## Memo

0.00

## Hand Finishing

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**\*96353\***

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Item ID: D4435-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Mount Bracket  
 Start Date: 1/24/13 Start Qty: 15.00 **\*15\*** Cust Item ID:  
 Required Date: 2/04/13 Req'd Qty: 15.00 **\*15\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 <b>*170*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00		SM3 13225		21			
190 <b>*190*</b> Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00 0.00		5109		2/x		SP 13-2-25	
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00						13/2/26 MF 13-2-26	

# Picklist Print

February-08-13 8:43:51 AM

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Work Order ID: 96353

Parent Item: D4435-5

Parent Item Name: Mount Bracket

Start Date: 1/24/13

Required Date: 2/04/13

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC  
DWG REV.B DD VERF:EC

IPP REV:B 12.03.06 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	760.7156	0.1732	27347368 3			Jm13 2.8
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		760.7156							
				121099		273.7156							
				123874		487				123874			

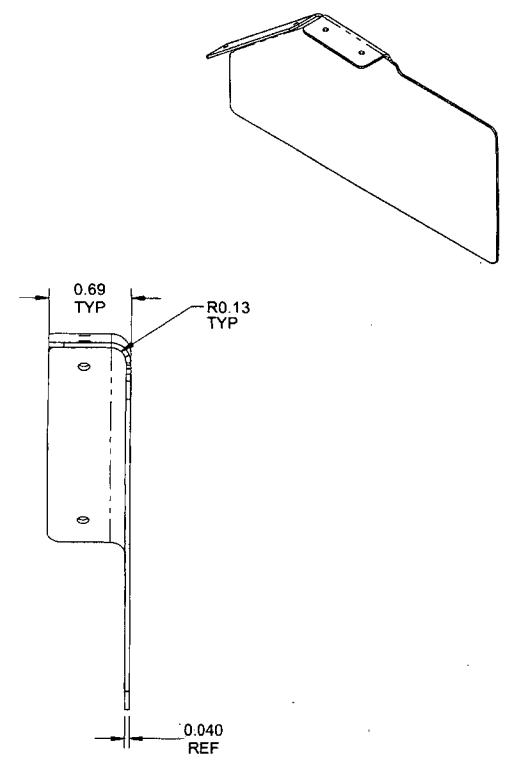
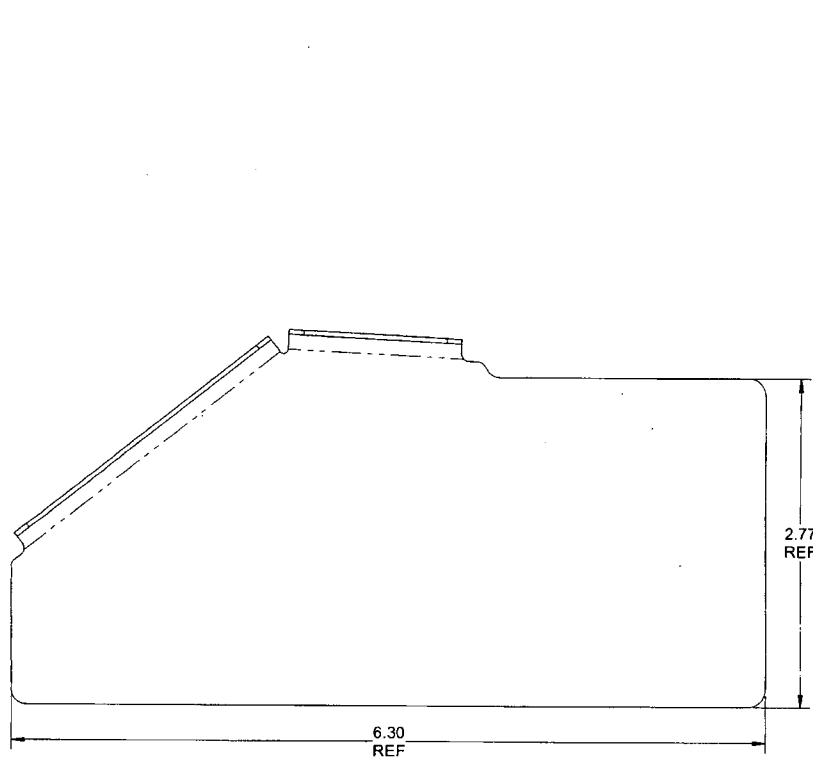
96283

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: Jm	Audited by: 15	Preliminary Approval:
Date: 13-2-8	Date: 13-2-8	Date:

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dwg Rev updated	KJ	



**D4435-5 MOUNT BRACKET**

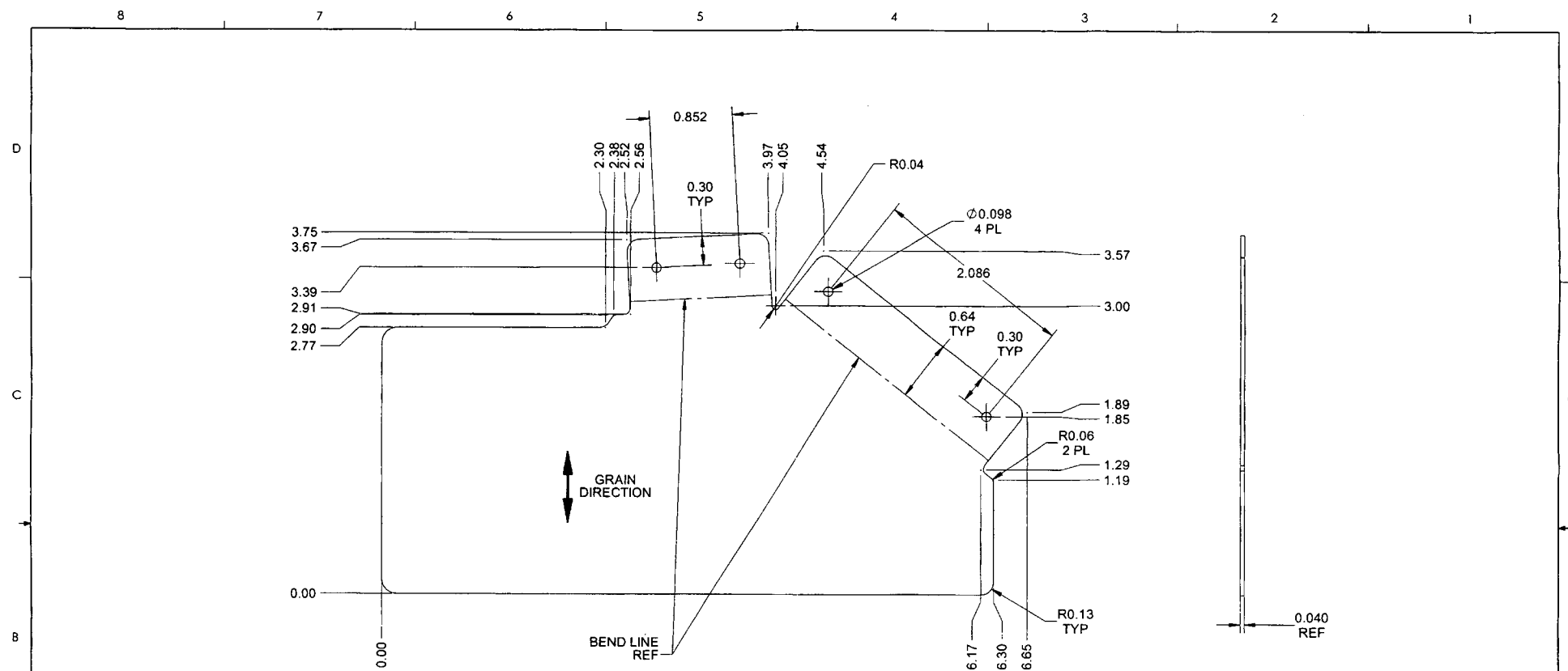
*w/o 96353*

**RELEASED**  
2012-03-02

**NOTES:**

- 1) MATERIAL: MAKE FROM D4435-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>W</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4435	SHEET 6 OF 11
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	BRACKET	NTS
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**D4435-5F FLAT PATTERN**

RELEASE  
2012-03-02

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040

- 2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>MF</i>	DRAWING NO. REV. E
MFG. APPR.	<i>MF</i>	D4435 SHEET 7 OF 1
APPROVED	<i>MF</i>	TITLE SCALE
DE APPR.	<i>MF</i>	BRACKET NTS
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